

Work Order ID 83266

83266

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April-16-12 1:36:17 PM

Item ID: D2438 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 16/04/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 30/04/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 12/04/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								
100	PURCHASING	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D2438								
<u>304 .063</u>	prog rev: <u>C</u>								
	dwg rev: <u>C</u>								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	Ensure Material Release Note is attached								
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								

50 0 OK JS
 12-5-12

50 0 OK JS
 12-5-12

cuts
(X) JS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 16/04/2012 **Start Qty:** 50.00 ***50***

Cust Item ID:

Required Date: 30/04/2012 **Req'd Qty:** 50.00 ***50***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

130

130

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

- 1- Use DT9713 clamp holder to hold clamp in place when forming
- 2- Bend as per dwg usind DT9709

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: ST456 0.00

0.00

150

Packaging

Memo

0.00

Packaging

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 16/04/2012 **Start Qty:** 50.00 ***50***

Cust Item ID:

Required Date: 30/04/2012 **Req'd Qty:** 50.00 ***50***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/16 *[Signature]*

ME
12-05-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 83266

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Parent Item: D2438

D2438

Parent Item Name: Clamp

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	234.1520	0.04	2.105263			

M304S16GA

**

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

234.152

120866

38.446

120877

137.326

121070

58.38

120877

cmf/Jm
12-5-12

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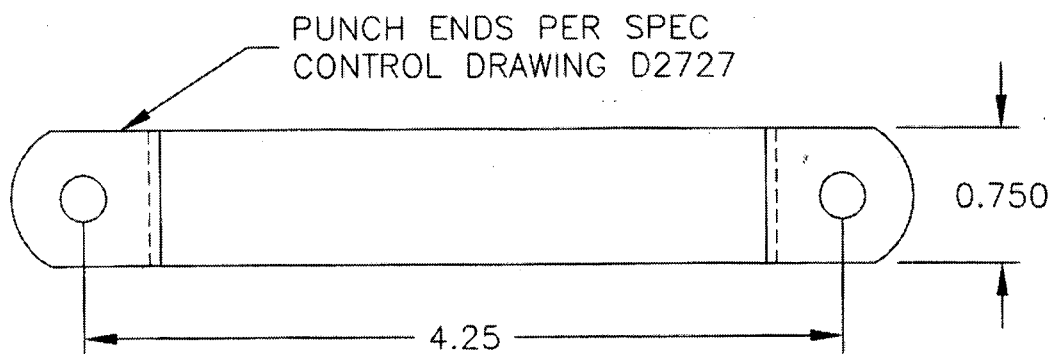
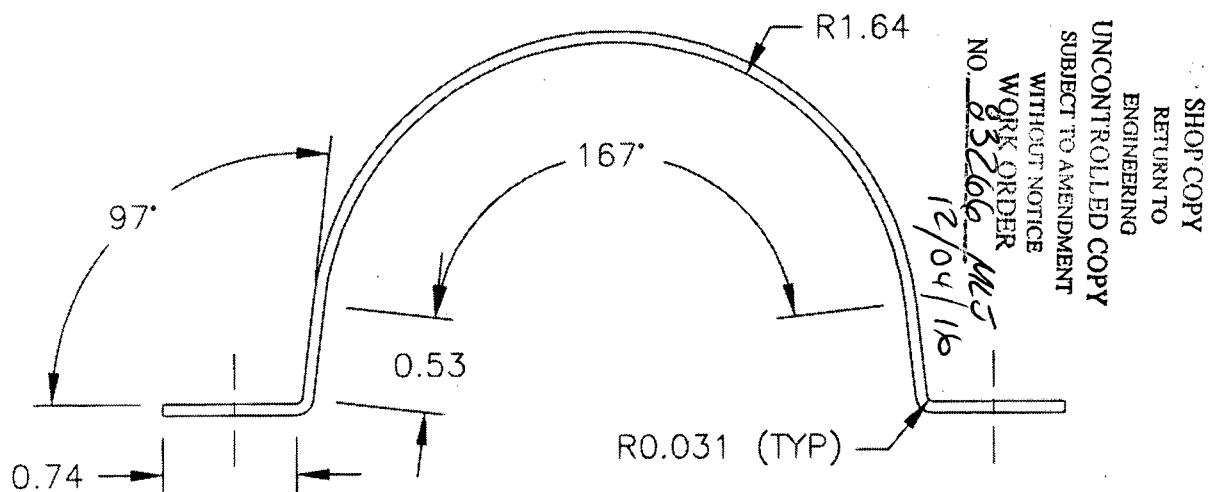
NOTE: Date & initial all entries

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>CS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
19.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

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